

Work Order ID 77355

December-06-11 10:27:58 AM

77355

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 06/12/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: M.L.JDate: 11/12/06

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100

100

DC

Document Control

DOCUMENT CONTROL

0.00

for M.L.J 12-1-10

110

110

Large Fab

Large Fab

0.00

5/7/11

(5)

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

12.01.03 5 φ

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

114514
119712

3-Grind End Plate flush

77355 5LH... ☺

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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5

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Quality Control

5 0 8E12-01-04

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Quality Control

8/20/04

15 _____
64 _____

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

0.00

1A 12-01-05

5 _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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5

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

150

QC3- Inspect Part Finish

150

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

180

Large Fab

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod 114514

6-Grind End Plate flush

7-Install last rivet as per Dwg.

→ Ae 12.01.06
12.01.06

(X5) ✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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5

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	12/01/13						
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8/20/13			75	LM		
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	BL	10-1-16	

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 30/01/2012 Req'd Qty: 5.00

5

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

220

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

SX/ML 12/01/17
LIT

Memo

8:15 0.00
320 0'
8:45

230

230

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 120125 0.00

Memo

0.00

SA. 12-1-17

240

240

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

SA. 12-1-17
COUNTERS IDENTIFIED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

12/11/12 SP/SC

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Quality Control

Memo

0.00

8/17/01/15

TS
44

270

270

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD350-591-311

Location: _____

12/11/12 SP/SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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December-06-11 10:27:58 AM

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Page 7

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Setup Start

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Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 06/12/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 *280* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/1/19 20 P120H9 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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December-06-11 10:28:01 AM

Page 1

Work Order ID: 77355

77355

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No		110	Each	20.0000	1	5			11/12.28	
---------	--	--------------	----	--	-----	------	---------	---	---	--	--	----------	--

D3272-1

Step

Location	Loc Qty	Loc Code
WA 377360	(5)	
76038	10	
76039	10	

D3067-1		Manufactured	No	110	Each	125.0000	1	5			11/12.01.02	
---------	--	--------------	----	-----	------	----------	---	---	--	--	-------------	--

D3067-1

End Plate

Location	Loc Qty	Loc Code
WA016	125	
67582	2	
68214	1	
75468	32	
76179	90	

D3219-1		Manufactured	No	110	Each	106.0000	2	10			11/12.01.02	
---------	--	--------------	----	-----	------	----------	---	----	--	--	-------------	--

D3219-1

Plate

Location	Loc Qty	Loc Code
WA016 71674	106	
73410	34	
76226	72	

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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December-06-11 10:28:01 AM

Page 2

Work Order ID: 77355

77355

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

D3066-1

Manufactured No

180

Each

148.0000

2

10

**

D3066-1

Spacer

Ac 12.01.06

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA015	148	
75076	48	
<u>76180</u>	100	<i>X10</i>

MS20600-AD4W4

Purchased No

180

Each

2,362.000

16

80

MS20600-AD4W4

Rivets

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST321 <u>m119883</u>	2357	<i>80</i>
116188	59	
117364	253	
117601	200	
117885	195	
118840	1150	
119860	500	
WA018	5	
116712	5	

D3065-041

Manufactured No

180

Each

33.0000

1

5

**

D3065-041

Step Leg Assembly Hi

B77054 (x5) Ac 12.01.06

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA <u>B77054</u>	33	<i>5</i>
66149	0	
76193	31	
76194	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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December-06-11 10:28:01 AM

Page 3

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77355
D350-591-311

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

D3067-1

Manufactured No

180

Each

125.0000

1

5

**

D3067-1

End Plate

Location	Loc Qty	Loc Code
----------	---------	----------

WA016	125	
67582	2	
68214	1	
75468	32	
76179	90	

AN3-35A

Purchased No

250

Each

145.0000

2

10

**

Location	Loc Qty	Loc Code
----------	---------	----------

ST353	145	
117619	3	
119449	100	
119641	42	

D3235-1

Manufactured No

250

Each

147.0000

2

10

**

Location	Loc Qty	Loc Code
----------	---------	----------

ST481	147	
73411	47	
75547	100	

D3278-041

Manufactured No

250

Each

62.0000

1

5

**

D3278-041

Support Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

ST481	62	
76169	35	
76170	27	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

AN960JD416

NAS1149D0463J Purchased

No

250

Each

0.0000

16

80

**

1119075

Washer

AN960JD516

NAS1149D0563J Purchased

No

250

Each

0.0000

4

20

**

1118206

Washer

AN5-36A

Purchased

No

250

Each

144.0000

2

10

**

1118206

AN5-36A

Bolt

Location Loc Qty Loc Code

ST340 144
118451 19
119449 50
119641 75

10

D2618

Manufactured

No

250

Each

152.0000

2

10

**

1118206

D2618

Bushing

Location Loc Qty Loc Code

ST019 152
74458 52
76130 100

10

D2230-3

Manufactured

No

250

Each

99.0000

4

20

**

1118206

D2230-3

Lug

Location Loc Qty Loc Code

ST480 99
53881 4
70973 1
74440 10
75546 84

10

10

10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-591-311
Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011
Start Qty: 5.00

Required Date: 30/01/2012
Required Qty: 5.00

D2856-400 Manufactured No

250 f 252.2445 1.2

**

D2856-400

Abraison Strip

Location	Loc Qty	Loc Code
ST409	252.2445	
63735	0.6696	
68076	0.3149	
71164	37.86	
73491	213.4	6

→ measured
12/01/16

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3 Purchased No

250 Each 7,467.000

**

MS21042L3

Nut

Location	Loc Qty	Loc Code
ST300	87	
117441	16	
117885	35	
118451	5	
118927	31	
ST516	5994	
119017	5994	10
ST518	1386	
119075	1386	

AN4-13A Purchased No

250 Each 981.0000

**

AN4-13A

Bolt

Location	Loc Qty	Loc Code
ST357	981	
118078	17	
118838	364	
119449	500	40
119798	100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 6

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

250

Each

2,192.000

2

**

*J****MS210421 5***

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	692	
116105	5	
116548	43	
117611	52	
118179	496	
<u>118910</u>	96	<u>10</u>
ST518	1500	
119109	1500	

MS21042L4

Purchased

No

250

Each

10,136.00

8

*J****MS210421 4***

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	531	
117441	51	
117601	347	
118451	133	
ST516	4605	
<u>119017</u>	4605	<u>40</u>
ST518	5000	
119075	5000	

AN960JD10

NAS1149D0363J Purchased

No

250

Each

0.0000

4

20

**

*11/12/2012 J 12/1/12 52****AN960.JD10***

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *TH*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77355 M.L.O

11/12/06

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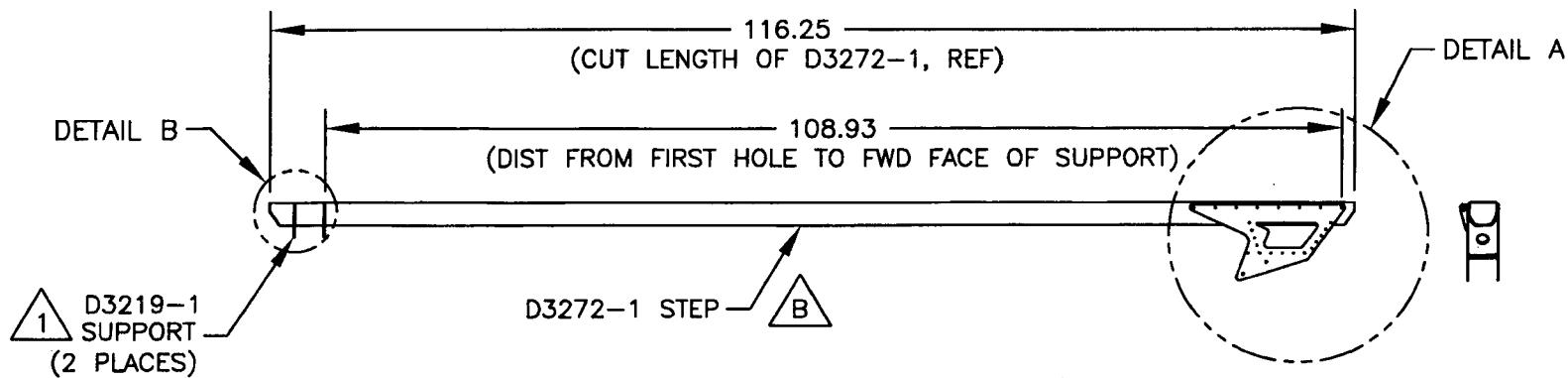
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

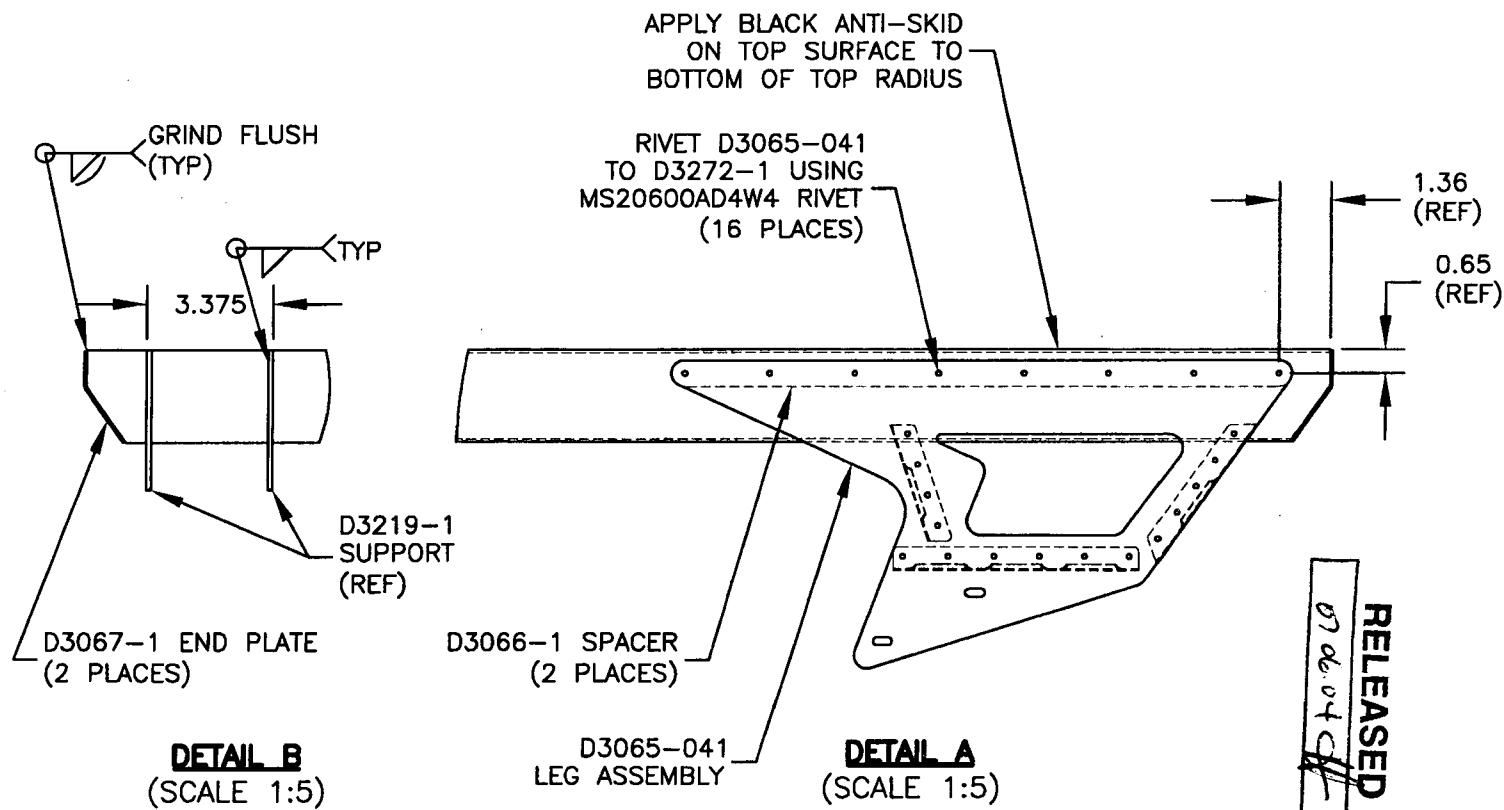
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77355

DART

D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	DRAWN BY	DART AEROSPACE LTD
90	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3272
DATE	TITLE	REV. B
07.05.18	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
SCALE		1:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

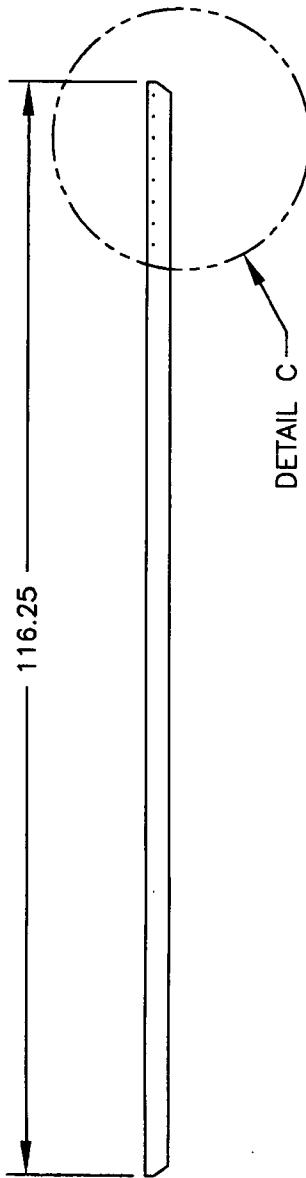
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

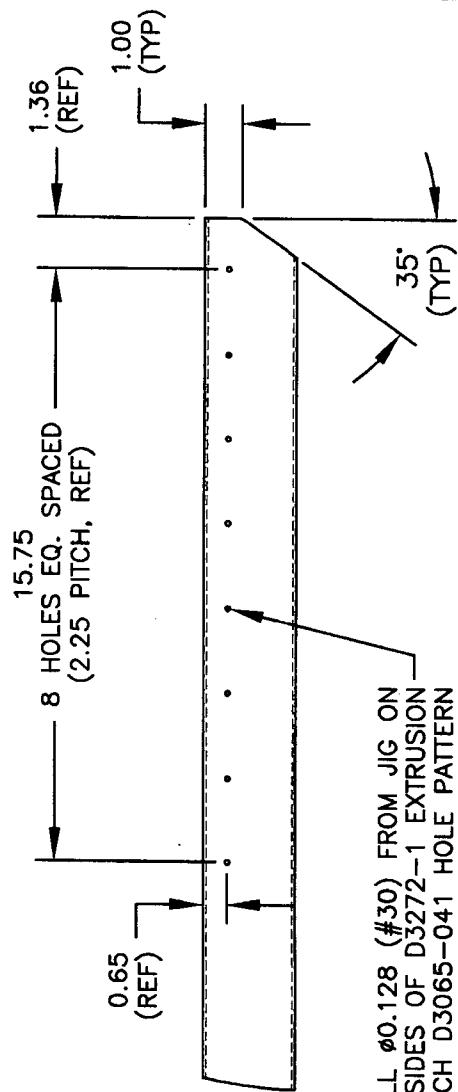
NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



△ D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

**RELEASED**07.06.04 *SH*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
	X					1	1	D350-591-211	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
	X							D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
		X						D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X						D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X					D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X				D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X			D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	1	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						1	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	1	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						1	2	D3235-1	MOUNTING LUG
							1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	1	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	1	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	1	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						1	4	AN960JD516	WASHER
2	2	2	2	2	2	1	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						1	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore NOT REQUIRED to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.